

Date: Monday, 8/21/2006 2:14:24 PM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PLUG
Job Number :	28276		
Estimate Number :	12338		
P.O. Number :	N/A	Part Number :	D3492045
This Issue :	8/21/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3492 UNDER REVIEW
First Issue :	N/A	Project Number :	N/A
Previous Run :	27192	Drawing Revision :	UNDER REVIEW
Written By :		Material :	N/A
Checked & Approved By :		Due Date :	9/5/2006
Comment :	Est Rev: A 06.03.21 New Issue JLM		

Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.0656 f(s)/Unit Total : 2.6250 f(s)
6061-T6 Round Bar .500"
(M6061T6R500)
Batch: M60421

J.F. 06/08/29 43

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA634 & Dwg D3492
Dwg Rev: A
Folio Rev: A

J.F. 06/08/29 43

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/08/29 43

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

J.F. 06/08/29 43

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

J.F. 06/08/29 43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 8/11/02

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:14:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 28276

Part Number: D3492045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/09/02

(42)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

a.m. 06/09/02

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 11 01

(42)

9.0

NAS1611003

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-003 O-RING

M111519

NAS1611-005 PH
P.T.O. 06.05.21

a.m. 06/11/02

(43)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch: M 101223

a.m. 06/11/02

(43)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 06 11 02

(42)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

a.m. 06/11/02

(42)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/11/02
U 06/11/01

(42)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06.03.21	9	CHANGE NAS1611-003 O-RING TO NAS1611-005 O-RING PERMANENT CHANGE. DWG updated after DIS-751 is complete	RH 06.03.21 per QSS 0-12					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

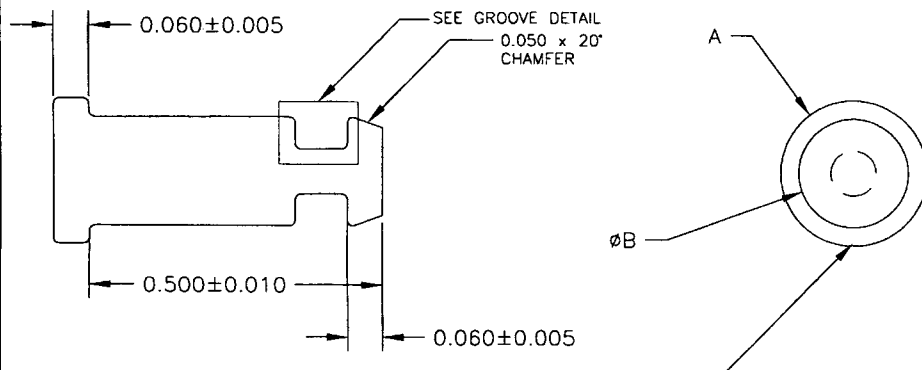
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



D3492-1/-3/-5 PLUGS IN ACCORDANCE WITH TABLE 1

D3492-1/-3/-5 PLUG IN ACCORDANCE WITH TABLE 2

NAS1611-003/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

D3492-041/-043/-045 PLUG ASSEMBLY

D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST
(TABLE 2)

Qty -041	Qty -043	Qty -045	Part Number	Description
X			D3492-041	PLUG ASSEMBLY
	X		D3492-043	PLUG ASSEMBLY
		X	D3492-045	PLUG ASSEMBLY
1			D3492-1	PLUG
	1		D3492-3	PLUG
		1	D3492-5	PLUG
		1	NAS1611-003	O-RING
1			NAS1611-010	O-RING
	1		NAS1611-013	O-RING

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.500	0.394	0.055	M6061T6R0.500
D3492-3	0.625	0.582	0.045	M6061T6R0.625
D3492-5	0.375	0.188	0.045	M6061T6R0.250

D3492-1/-3/-5 PLUG NOTES

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-O PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

USE
NAS1611-005
PH
06-03-21

UNDER REVIEW

06-07-04 PH

-045 PLUG NEEDS
NAS1611-005 O-RING

OK
For
B28276

RELEASED

06-02-07

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 28276
WORK ORDER

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.		A 06.01.04 NEW ISSUE	
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	
CHECKED #	APPROVED #	DRAWING NO. D3492	REV. A SHEET 1 OF 1
DATE 06.01.04	TITLE PLUG	SCALE NTS	

